



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
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D2274**Job Sheet 205396**

Part No: D2274

Job Qty: 100 pcs

Part Name: Radius Block



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/9/20

Job Tracking No:

Due Date: 2/7/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV F IPP H 00.05.18 Added inspection level 8 EC

Ship Via:

Bill of Materials**Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	DAS		
100	Shear - 1	100 pcs		2/7/20	0.00	0.05	Shear - 1	52 DAS	20/02/01	
110	HAAS 4 Axis - B4B	100 pcs		2/7/20	1.00	2.39	HAAS - 1 - B4B	52	20/02/01	
							HAAS - 2 - B4B	9-89		
							HAAS - 3 - B4B			
							HAAS - 4 - B4B			
130	QC 8	100 pcs		2/7/20	0.00	0.00	QC 8 - 12			
							QC 8 - 14		20/02/01	
							QC 8 - 17			
							QC 8 - 20			
							QC 8 - 25			
							QC 8 - 3			
							QC 8 - 32			
							QC 8 - 33			
							QC 8 - 35			
							QC 8 - 39			
							QC 8 - 4			
							QC 8 - 44			
							QC 8 - 45			
							QC 8 - 49			
							QC 8 - 58			
							QC 8 - 8			
							QC 8 - 9			
							QC 8 - 68			
							QC 8 - 67			
							QC 8 - 1 (A)			
							QC 8 - 47			
							QC 8 - 40			
							QC 8 - 52			
							QC 8 - 23			
							QC 8 - 57			



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Container No: S252730



Part: D2274

Job No: 205396

Serial No/Batch: S252730

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/01/20

				QC 8 - 76						
				QC 8 - 61						
140 Small Fab - 2 - B4B	100 pcs	2/7/20	0.00 0.54	Small Fab - 1 - B4B	ML 20/02/20					
				Small Fab - 2 - B4B						
				Small Fab - 3 - B4B						
				Small Fab - 4 - B4B						
				Small Fab - 5 - B4B						
				Small Fab - 6 - B4B						
				Small Fab - 7 - B4B						
				Small Fab - 8 - B4B						
				Small Fab - 9 - B4B						
				Small Fab - Various 1 - B4B						
150 Handfinish - 1-1 Chemical-B4B	100 pcs	2/7/20	0.00 0.26	Handfinish - 1 - 1 - B4B	ML 20.2-24					
				Handfinish - 1 - 2 - B4B						
				Handfinish - 1 - 3 - B4B						
				Handfinish - 1 - 4 - B4B						
				Handfinish - 1 - 5 - B4B						
				Handfinish - 1 - 6 - B4B						
				Handfinish - 1 - 7 - B4B						
				Handfinish - 1 - 8 - B4B						
				Handfinish - 1 - 9 - B4B						
				Handfinish - 1 - 10 - B4B						
				Handfinish - 1 - 11 - B4B						
				Handfinish - 1 - 12 - B4B						
				Handfinish - 1 - 13 - B4B						
				Handfinish - 1 - 14 - B4B						
				Handfinish - 1 - 15 - B4B						
				Handfinish - 1 - 16 - B4B						
				Handfinish - 1 - 17 - B4B						
				Handfinish - 1 - 18 - B4B						
				Handfinish - 1 - 19 - B4B						
				Handfinish - 1 - 20 - B4B						
				Handfinish - 1 - 21 - B4B						
				Handfinish - 1 - 22 - B4B						
160 QC 7	100 pcs	2/7/20	0.00 0.00	QC 7 - 10						
				QC 7 - 13						
				QC 7 - 14						
				QC 7 - 15						
				QC 7 - 17						
				QC 7 - 18						
				QC 7 - 19						
				QC 7 - 2						
				QC 7 - 28						
				QC 7 - 3						
				QC 7 - 30						
				QC 7 - 34						
				QC 7 - 36						
				QC 7 - 37						
				QC 7 - 41						
				QC 7 - 47						
				QC 7 - 48						
				QC 7 - 51						
				QC 7 - 58						
				QC 7 - 59						
				QC 7 - 60						
				QC 7 - 9						
				QC 7 - 68						
				QC 7 - 50						
								Plex 1/9/20 8:08 AM Dart.lajeunesse.marie		

					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	DAS 82
					QC 7 - 61	9-89
					QC 7 - 81	
					QC 7 - 76	FEB 26 2020
					QC 7 - 79	
					QC 7 - 83	
170	Packaging 3-1 - Stock - B4B	100 pcs	2/7/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	Stop 82 DAS FEB 26 2020
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	DAS
180	QC 21 - SA	100 pcs	2/7/20	0.00 0.00	QC 21 - SA - 21	21
					QC 21 - SA - 70	8-89
					QC 21 - SA - 53	FEB 26 2020
					Broussard	

Part Op 100 - (Shear) blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces
 Descriptions: 110 - (HAAS CNC vertical machine #1) Machine as per folio D2274
 130 - (QC8- Inspect parts - second check)
 140 - (Small Fab) Tumble Deburrr any rough edges after tumbling
 150 - (Chemical Conversion Coat per QSI005 4.1)
 160 - (QC7-Inspect Chemical Conversion Coat)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.750X00.125	6061-T6 Bar .750 X .125	8.3000 ft (.083 ea)	100-Shear - 1	5207690

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Shear - 1	M6061T6B0.750X00.125	8	41	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Radius Block	0.257inches + 0.005 - 0.000	0.262 0.257	0.257	
2	Radius Block	0.750inches ± 0.010	0.760 0.740	0.755	
3	Radius Block	0.375inches ± 0.010	0.385 0.365	0.375	
4	Radius Block	0.125inches ± 0.010	0.135 0.115	0.125	
5	Radius Block	0.750inches ± 0.010	0.760 0.740	0.755	
6	Radius Block	0.063inches ± 0.010	0.073 0.053	0.063	

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only



Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS		MRB (QS1042)																	
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QS1042)																	
Description Work Order Deviation		Disposition																					
Root Cause <table border="1"><tr><td>Operator</td><td></td></tr><tr><td>Manufacturing Process</td><td></td></tr><tr><td>Equip/Tooling</td><td></td></tr><tr><td>Handling/Preservation</td><td></td></tr><tr><td>Material</td><td></td></tr><tr><td>Product Improvement</td><td></td></tr><tr><td>Process Improvement</td><td></td></tr><tr><td>Human Factors</td><td></td></tr></table>		Operator		Manufacturing Process		Equip/Tooling		Handling/Preservation		Material		Product Improvement		Process Improvement		Human Factors		Pressure/Forced		Contamination		Power Loss/Surge	
		Operator																					
Manufacturing Process																							
Equip/Tooling																							
Handling/Preservation																							
Material																							
Product Improvement																							
Process Improvement																							
Human Factors																							
Bending		Misaligned/off center		Folio/Program		Positioned Wrong																	
Crushing		BOM/Route		Grain Direction		Outside Tolerance																	
Cracks		Broken/Damage/Defect		Weld		Drawing																	
Crimp/Kink/Ripple/Wave/Twist		Incomplete/Unclear Instructions		Wrong Stock Pulled		Finish																	
Marks/Chatter		Drill Holes		Out of Sequence		Part Lost/Missing																	
Mislabeled		Fit/Function		Off-set/Set-up		Misread																	
Other/Details:																							
Completed By		Lead hand / Supervisor																					
QC / QA Coordinator																							